

**Amendments to the Specification:**

Please replace Table 2 on page 29 with the following table:

Sample No.	Coating layer *						Cooling rate (°C/min.)	F <sub>1</sub> /F <sub>0</sub>	Observation in cross-sectional direction		Observation in surface direction	
	Base layer	First layer	Second layer	TiCN layer	Third layer	Middle layer			TiCN particle	Aspect ratio	TiCN particle	Aspect ratio
1-1	TiN (0.5)	TiCN1<2> (6.0)[0.3]	TiCN4<2> (3.0)[1.0]	—	—	TiCN0 (45NF <sub>0</sub> )	20	3.1	Column	13	Acicular	5
1-2	TiN (0.6)	TiCN1<2> (3.0)[0.3]	TiN (2.0)[0.3]	TiCN3<2> (2.0)[0.3]	TiCN4<2> (0.8)[1.0]	TiCN0 (80NF <sub>0</sub> )	20	1.14	Column	10	Acicular	6
1-3	TiN (1)	TiCN1<2> (3.0)[0.3]	TiCN3<2> (2.0)[0.3]	TiCN3<2> (2.0)[0.3]	—	TiCN0 (80NF <sub>0</sub> )	15	15.0	Column	14	Acicular	6
1-4	Nothing	TiCN4<2> (0.3)[1]	TiCN1<2> (4.0)[0.3]	TiCN3<2> (4.0)[0.3]	TiCN3<2> (4.0)[0.3]	TiCN0 (80NF <sub>0</sub> )	25	2.3	Column	8	Acicular	3
1-5	TiN (0.6)	TiCN1<2> (4.0)[0.3]	TiCN3<2> (3.0)[0.8]	TiCN3<2> (3.0)[0.8]	—	TiCN0 (80NF <sub>0</sub> )	15	6.0	Column	7	Acicular	5
1-6	Nothing	TiCN2<2> (1.0)[0.3]	TiCN3<2> (4.0)[0.3]	TiCN3<2> (4.0)[0.3]	TiCN4<2> (2.0)[1.0]	TiCN0 (80NF <sub>0</sub> )	25	1.3	Column	8	Acicular	4
1-7	TiN (0.8)	TiCN3<2> (0.3)[0.8]	TiCN3<2> (3.0)[0.8]	—	—	TiCN0 (80NF <sub>0</sub> )	10	1.0	Column	3	Isotropic	1.2
1-8	Nothing	TiCN3<2> (0.3)[0.8]	TiCN2<2> (3.0)[0.4]	—	—	TiCN0 (80NF <sub>0</sub> )	20	1.03	Column	6	Isotropic	1.5
1-9	TiN (0.6)	TiCN1<2> (7.0)[0.3]	—	—	—	TiCN0 (80NF <sub>0</sub> )	40	33.0	Column	20	Acicular	8
1-10	Nothing	TiCN5<2> (6.0)[0.5]	—	—	—	TiCN0 (80NF <sub>0</sub> )	20	29.0	Column	10	Acicular	4

\* ( ) represents layer thickness and [ ] represents a mean crystal width. Unit:  $\mu\text{m}$   
 TiCN<2> and TiCN0 respectively represent columnar TiCN and particulate TiCN.  
 The peeling load (N) of each layer is shown at the bottom of each coating layer. "—" means that the layer peels together with a layer on it.

Please replace Table 3 on page 31 with the following table:

Sample No.	Wear resistance test: wear amount (mm)		Fracture resistance test Number of impacts before fracture (times)	Condition of hard coating layer
	Flank wear	Wear at the tip		
I- 1	0.14	0.13	5000	Minute peeling of Al <sub>2</sub> O <sub>3</sub> layer
I- 2	0.22	0.20	4300	Minute peeling of Al <sub>2</sub> O <sub>3</sub> layer
I- 3	0.20	0.18	4000	Minute peeling of Al <sub>2</sub> O <sub>3</sub> layer
I- 4	0.12	0.11	4700	Minute peeling of Al <sub>2</sub> O <sub>3</sub> layer
I- 5	0.19	0.17	4500	Minute peeling of Al <sub>2</sub> O <sub>3</sub> layer
I- 6	0.17	0.16	4700	Minute peeling of Al <sub>2</sub> O <sub>3</sub> layer
I- 7	0.35	0.32	1100	Large chipping (Exposure of base material)
I- 8	0.40	0.41	2500	Large chipping (Exposure of base material)
I- 9	0.43	0.40	1700	Peeling of Al <sub>2</sub> O <sub>3</sub> layer
I- 10	0.23	0.22	4000	Minute peeling of Al <sub>2</sub> O <sub>3</sub> layer